

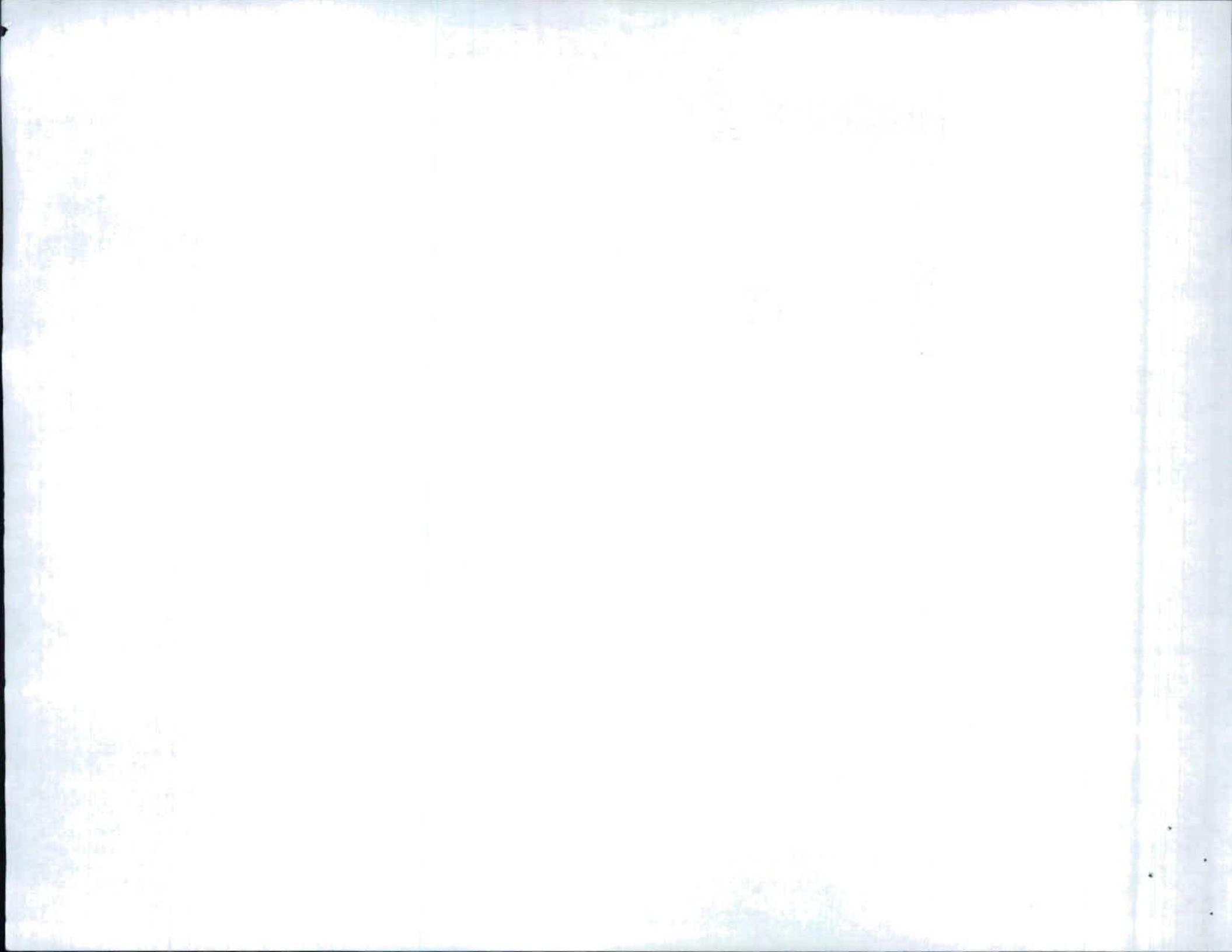
① FWD ADJUSTABLE BLADE SUPPORT ASSY

SCANNED - 9-200

* 40606

1 -13 AFT ADJUSTABLE BLADE SUPPORT ASSY

ORIGINAL



Date: Thursday, 24/07/2008 8:20:48 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40606

Part Number: PB674300111

Job Number:



Seq. #:	Machine Or Operation:	Description :
20.0	QC5	INSPECT WORK TO CURRENT STEP <i>Sos/08/26 63</i>
21.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>39952</i>
22.0	QC21	FINAL INSPECTION/W/O RELEASE <i>08/08/26 18</i>

Job Completion



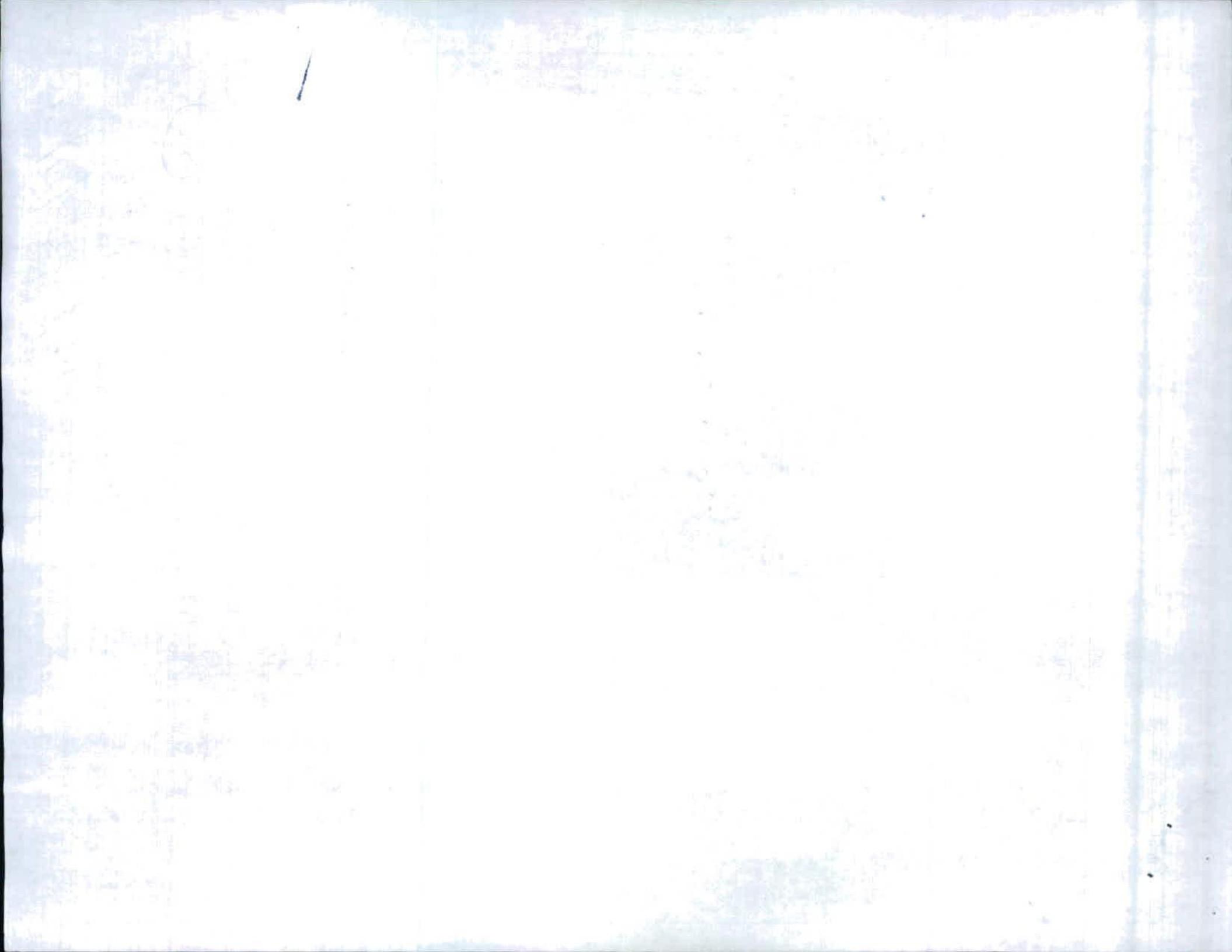
u 08.08.26



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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY
Job Number: 40606		Part Number: PB674300111
Job Number:		
Seq. #:	Machine Or Operation:	Description :
14.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION
15.0	PB674300169	90 Degree Cover Plate Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) 90 Degree Cover Plate batch: <u>40069</u>
16.0	PB674300183	PB67-43001-83 Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) PB67-43001-83 batch: <u>40094</u>
17.0	MS27039110	Screw Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s) Screw batch: <u>18836</u>
18.0	NAS1149F0316P	WASHER Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s) WASHER batch: <u>106282 108700</u>
19.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- match drill cover to existing holes in support 2- assemble as per dwg



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Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- make a 0.090" chamfer in the 1.00" hole before welding
- 2- assemble parts and weld as per dwg

H 08-07-22 5

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M 08-07-22 5

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08-08-26 5

B 08-07-29 5

9.0 MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
HELICAL INSERT

17935.

K 08-07-29

5

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- grind weld flush in area of PB67-43001-249 only
- 2- tap drill for helicol
- 3- install helicol insert as per dwg

K/K 08-07-29

08-07-29 5

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08-07-29 5

12.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SIA

13.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

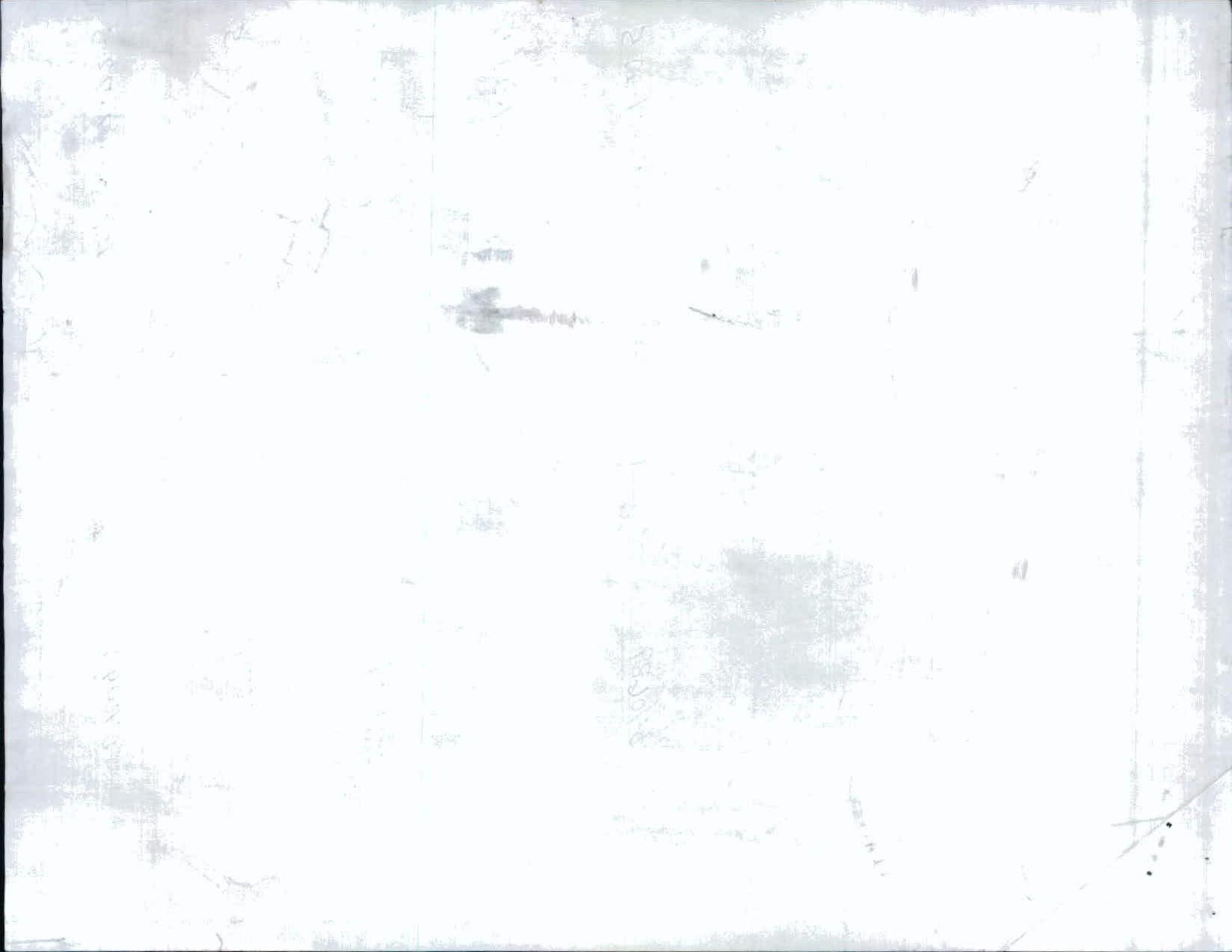
(5)

1- MASK TUBE FROM BASE TO GUSSET

> BK 08-07-31

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

M.F. 08/07/31



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Process Sheet

Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name:	FWD ADJUSTABLE BLADE SUPPORT ASSY
Job Number:	40606 -2	Part Number:	PB674300111
Estimate Number:	13435	Drawing Number:	B6743001 P.8
P.O. Number:		Project Number:	N/A
This Issue:	24/07/2008	S.O. No.:	
Prsht Rev.:	NC	Drawing Revision:	B1
First Issue:	17/07/2008	Type:	LARGE FAB ASSY
Previous Run:		Material:	
Written By:		Due Date:	24/07/2008
Checked & Approved By:	MF 08-07-24	Qty:	5
Comment:	Est Rev:A 08-06-26 new issue DD verified by:ec	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PB6743001247	Inner Tube	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Inner Tube batch: 340689	
2.0	PB6743001249	Inner Tube Bushing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Inner Tube Bushing batch: 10537	
3.0	PB6743001253	Gusset	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Gusset batch: 340045	
4.0	PB6743001254	Gusset	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Gusset batch: B40053	
5.0	PB674300167	PB67-43001-67	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) PB67-43001-67 batch: 340243	